

Date: Thursday, 24/07/2008 8:21:26 AM
User: Melanie Fauteux

Process Sheet

Duplicate

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40607
Estimate Number : 13436
P.O. Number :
This Issue : 24/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 17/07/2008 Type : LARGE FAB ASSY
Previous Run :
Written By :
Checked & Approved By : *mf 08-07-24*
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : AFT ADJUSTABLE BLADE SUPPORT ASSY
Part Number : PB674300113
Drawing Number : B6743001 P.8
Project Number : N/A
Drawing Revision : B1
Material :
Due Date : 24/07/2008 Qty: *3* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001255 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Inner Tube
batch: *40591*

PK 08.07.22

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Inner Tube Bushing
batch: *m18147*

PK 08.07.22

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Gusset
batch: *340717*

PK 08.07.22

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Gusset
batch: *340053*

PK 08.07.22

5.0 PB674300167 PB67-43001-67



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
PB67-43001-67
batch: *340243*

PK 08.07.22

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Job Number: 40607

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

BF 08-07-28.5

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-29 (S)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/29 (S)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
HELICAL INSERT

M 14935 BF

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

BF 08-07-31

(S)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/31 (S)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 4 08-07-31

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M 102316 08/07/31

(SX)

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Job Number: 40607

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
320 °F
2:10

m-f

08/07/31

(5X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

fd 08/07/31

(5)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

90 Degree Cover Plate

batch: 840069

HE 08-08-26

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-83

batch: 40096

HE 08-08-26

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch: 109031

HE 08-08-26

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch: m109031

HE 08-08-26

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

HE 08-08-26

3

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Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 (X3)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Pat E

CMF 08-08-26

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/27

CMF 08-08-26

Job Completion





